

Work Order ID 63607

Thursday, November 04, 2010 12:59:42 PM



Page 1

Item ID: DSI 9363-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Shim

Start Date: 11/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/15/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-11-09

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9363

Rev A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPDSI 9363

CHG001

Sulube

10/11/10

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10/11/10

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

Sulube

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63607



Page 2

Thursday, November 04, 2010 12:59:42 PM

Item ID: DSI 9363-011

Accept



Setup Start



Revision ID:

Item Name: Shim

Stop



Start Date: 11/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP DSI 9363-011								
	Location: 20								
	Rev: 17								
140		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

11/4/26

10/11/26

ME 10-11-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, November 04, 2010 12:59:47 PM

Work Order ID: 63607

Parent Item: DSI 9363-011

Parent Item Name: Shim



Start Date: 1/4/2010

Required Date: 11/15/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-08-30 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

8 D3238-21 Plate		Manufactured	No			120	Each	9.0000	6	6			
---------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location Loc Qty Loc Code

ST046 9

56296 9

8 D3238-23 Plate		Manufactured	No			120	Each	6.0000	2	2			
---------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location Loc Qty Loc Code

ST046 6

37587 2

56412 4

6 D3238-25 Plate		Manufactured	No			120	Each	10.0000	4	4			
---------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

ST046 10

37588 2

56413 8

6 D3238-31 Plate		Manufactured	No			120	Each	11.0000	12	12			
---------------------	--	--------------	----	--	--	-----	------	---------	----	----	--	--	--

Location Loc Qty Loc Code

ST046 11

53470 11

B636821X

11

10/11/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 2

Thursday, November 04, 2010 12:59:47 PM

Work Order ID: 63607

Parent Item: DSI 9363-011

Parent Item Name: Snim



Start Date: 11/4/2010

Required Date: 11/15/2010

Start Qty: 1.00

Required Qty: 1.00

5 D3238-33

 Plate

Manufactured No

120 Each

16.0000

4 4



10/11/10 SD

Location

Loc Qty

Loc Code

ST046

16

50247

16

Manufactured No

120 Each

39.0000

8 8



10/11/10 SD

10

Location

Loc Qty

Loc Code

ST046

39

42230

39

8

D3238-35

 Plate

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. DSI 9363	REV. A SHEET 1 OF 1
DATE 07.01.19		TITLE SHIM KIT	SCALE NTS
A	07.01.19	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-694 REV. B AND INSTRUCTIONS FOR CONTINUED
AIRWORTHINESS ICA-D412-694 REV. 1

REF. CANADIAN STC: SH05-10
REF. FAA STC: SR02086NY

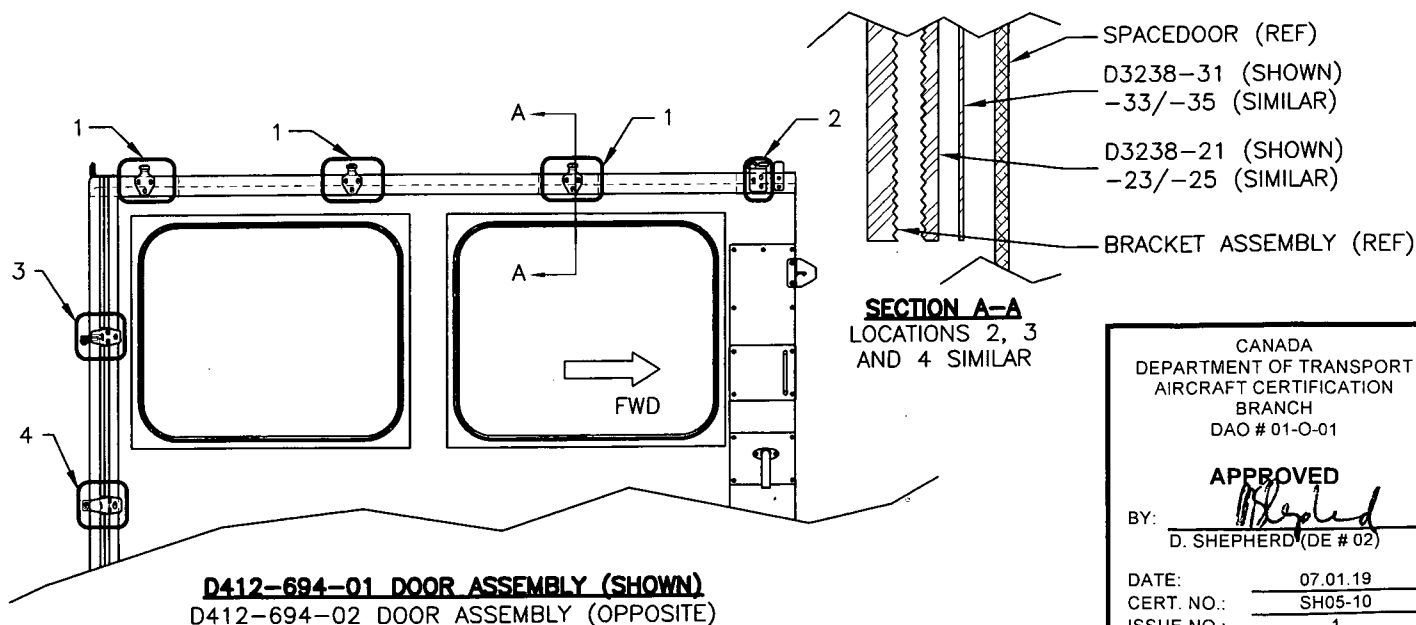
REFERENCE

Dart has created the optional DSI-9363-011 Shim Kit that may be installed between the D3121-041/-043/-044, D3183-041/-042 and D3137-041 Bracket Assemblies and the Spacedoor™ to improve grip between the Bracket Assemblies and the Spacedoor™. This kit may be installed as a replacement for or in addition to the AN960JD10 Washers and/or the D3090-1/-3 Shims used to shim the Bracket Assemblies as described in the Installation Instructions.

The serrated faces of the D3238-21/-23/-25 Plates should be installed against the serrated faces of the Bracket Assemblies to ensure positive locking as shown in **Section A-A**. The D3238-31/-33/-35 Plates, the AN960JD10 Washers and the D3090-1/-3 Shims can be installed as required between the D3238-21/-23/-25 Plates and the Spacedoor™ to achieve good door alignment.

The Table and Figure below show the location, the quantity and the part number of each Plate and the corresponding Bracket Assemblies on the Spacedoor™.

Qty	Part Number	Description	Used to Shim Bracket Assembly P/Ns	Location
X	DSI-9363-011	SHIM KIT		
6	D3238-21	PLATE	D3121-041	1
12	D3238-31	PLATE	D3121-041	1
2	D3238-23	PLATE	D3121-043/-044	2
4	D3238-33	PLATE	D3121-043/-044	2
4	D3238-25	PLATE	D3183-041/-042, D3137-041	3, 4
8	D3238-35	PLATE	D3183-041/-042, D3137-041	3, 4



Copyright © 2007 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.